

Shp Rudy Sm 6

Work Order ID 78342

78342

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January-05-12 1:48:24 PM

Item ID: D2196

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 1/05/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/06/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2196

Rev C

100

0.00

100


Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

 12/01/06 (V)

110

QC5- Inspect part completeness to step on W/O

0.00


110

QC

Memo

0.00

Quality Control

 12-01-06 (V)

120

0.00

120

Powdercoat

Memo

0.00

Powder Coating

Start Time: 2:45
Temp: 400°F
Finish Time: 3:15

 M-12/01/06

W 11/4/80

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Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 1/05/12

Start Qty: 1.00

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Cust Item ID:

Required Date: 1/06/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

12/1/9

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

Packaging

12/1/9

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/1/9

UMC
12-01-09

Picklist Print

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Work Order ID: 78342

Parent Item: D2196

Parent Item Name: Bracket

Start Date: 1/05/12

Required Date: 1/06/12

Start Qty: 1.00

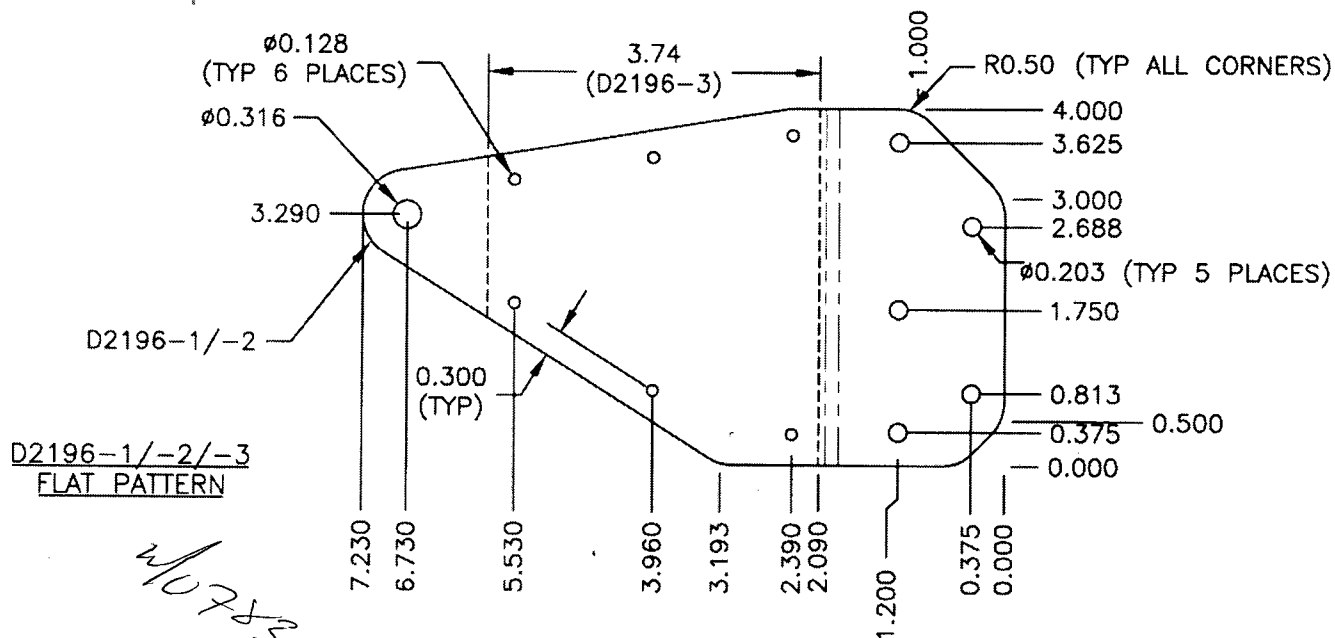
Required Qty: 1.00

Comments: IPP REV:A 12/01/05 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2196-1 Bracket		Manufactured	No			100	Each	3.0000	1	1		12/01/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		2							
				40760		2							
				ST006		1							
				62769		1							
D2196-2 Bracket		Manufactured	No			100	Each	3.0000	1	1		12/01/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		2							
				40764		2							
				ST006		1							
				62770		1							
D2196-3 Spacer		Manufactured	No			100	Each	3.0000	1	1		12/01/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		3							
				60056		1							
				62771		2							
MS20470AD4-14 Rivet		Purchased	No			100	Each	220.0000	6	6		12/01/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST320		220							
				1046		170							
				109059		50							



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D2196	SHEET 1 OF 1
DATE	03.05.28			TITLE	SCALE
				BRACKET	1:2
B	93.09.23			REDESIGN	
C	03.05.28			REDRAW; D2196-3 NOW 0.5" THICK	



D2196-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2196-3

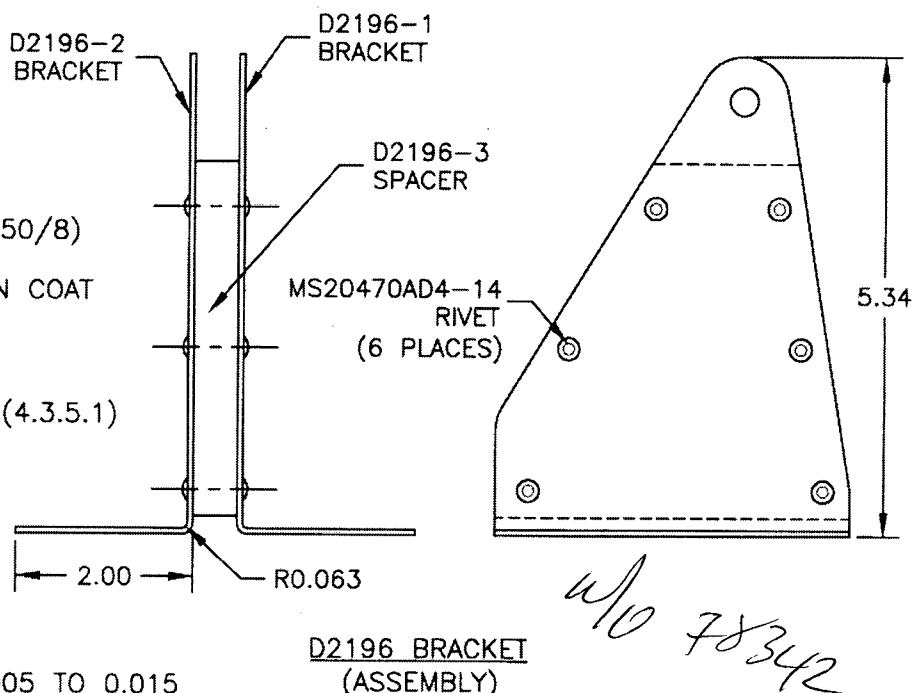
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2196 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



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